

Date: Thursday, 23/10/2008 1:30:41 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER MOTOR SUPPORT
Job Number	: 42905		
Estimate Number	: 12311		
P.O. Number	:	Part Number	: D3471041
This Issue	: 23/10/2008 S.O. No. :	Drawing Number	: D3471 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 34066	Material	:
Written By	:	Due Date	: 10/11/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>JLD 08.10.23</u>		
Comment	: est rev A 06.03.02 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3471043	Support & Clamp Assembly
-----	----------	--------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Pick:

-4	qty	part number	description	batch
	2	D3471-043	CLAMP ASS'Y	B42 923

SB 08/12/10 (2)

2.0	MS20470AD45	Rivet, Universal Head
-----	-------------	-----------------------



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)
 Pick:

qty	part number	description	batch
8	MS20470AD4-5	Rivet	M106914

SUR

3.0	D34711	Base
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 BASE

B26612

M34413

8/10/30

(2x)

SEP

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Assemble as per dwg D3471

FF 08/12/17

(2)

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/06 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 1:30:41 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 42905

Part Number: D3471041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: STISS

JS 09/01/07 (re)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 09/01/07 (2)

Job Completion



U 09.01.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

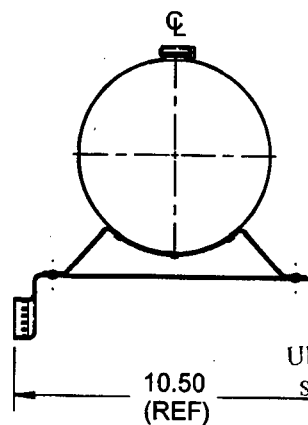
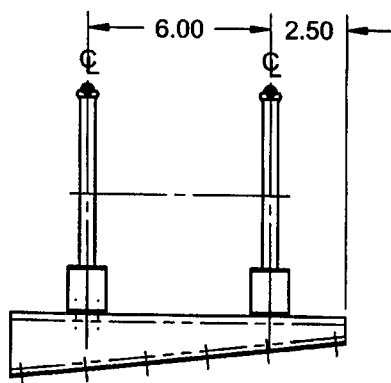
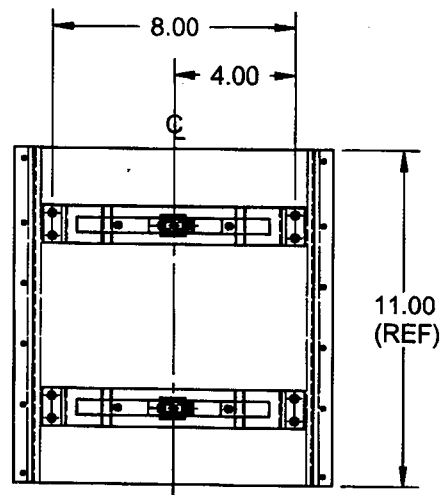
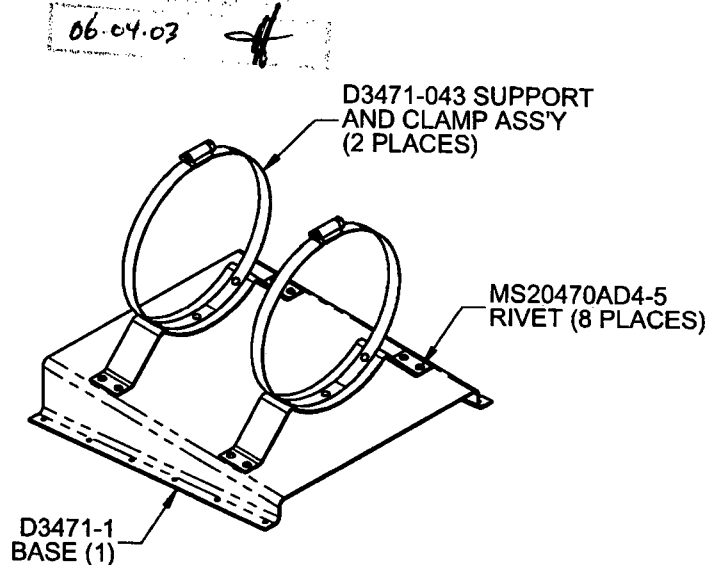
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3471	REV. A SHEET 1 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:6
A	05.12.21	NEW ISSUE	



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D3471-041 BLOWER MOTOR SUPPORT

NOTES:

- 1) IDENTIFY WITH DART P/N D3471-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3471-041	BLOWER MOTOR SUPPORT
2	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-1	BASE
8	MS20470AD4-5	RIVET

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3471	REV. A
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SHEET 2 OF 5 SCALE 1:3

06.04.03 *[Signature]*

LOCATE AND TRANSFER DRILL
#30 ($\varnothing 0.129$) THRU HOLE FROM
D3471-3 TO MS35842-16 CLAMP
AND C'SINK $\varnothing 0.230 \times 100^\circ$
(3 PLACES)

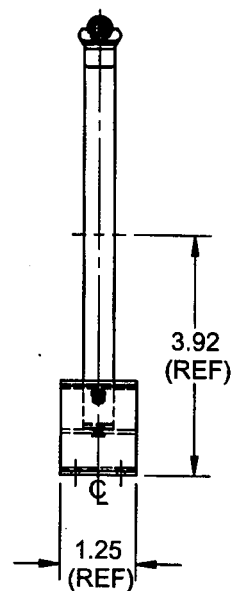
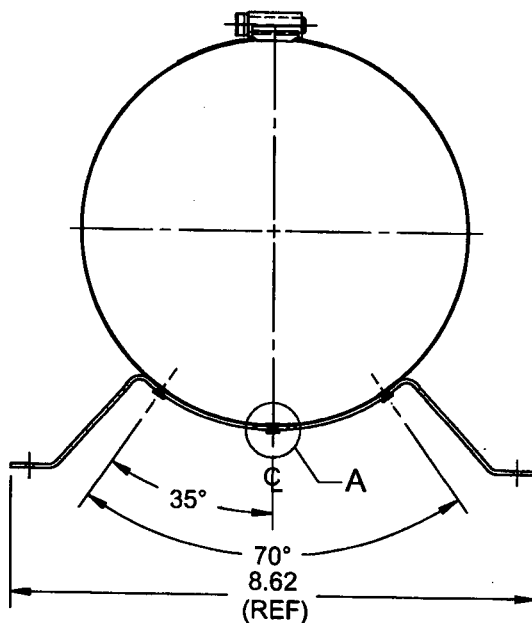


DETAIL A: COUNTERSINK HOLES
(RIVET NOT SHOWN FOR CLARITY)
SCALE 1:1

MS20427M4-4 RIVET
(3 PLACES)

MS35842-16
CLAMP

D3471-3
SUPPORT



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D3471-043 SUPPORT & CLAMP ASS'Y

NOTES:

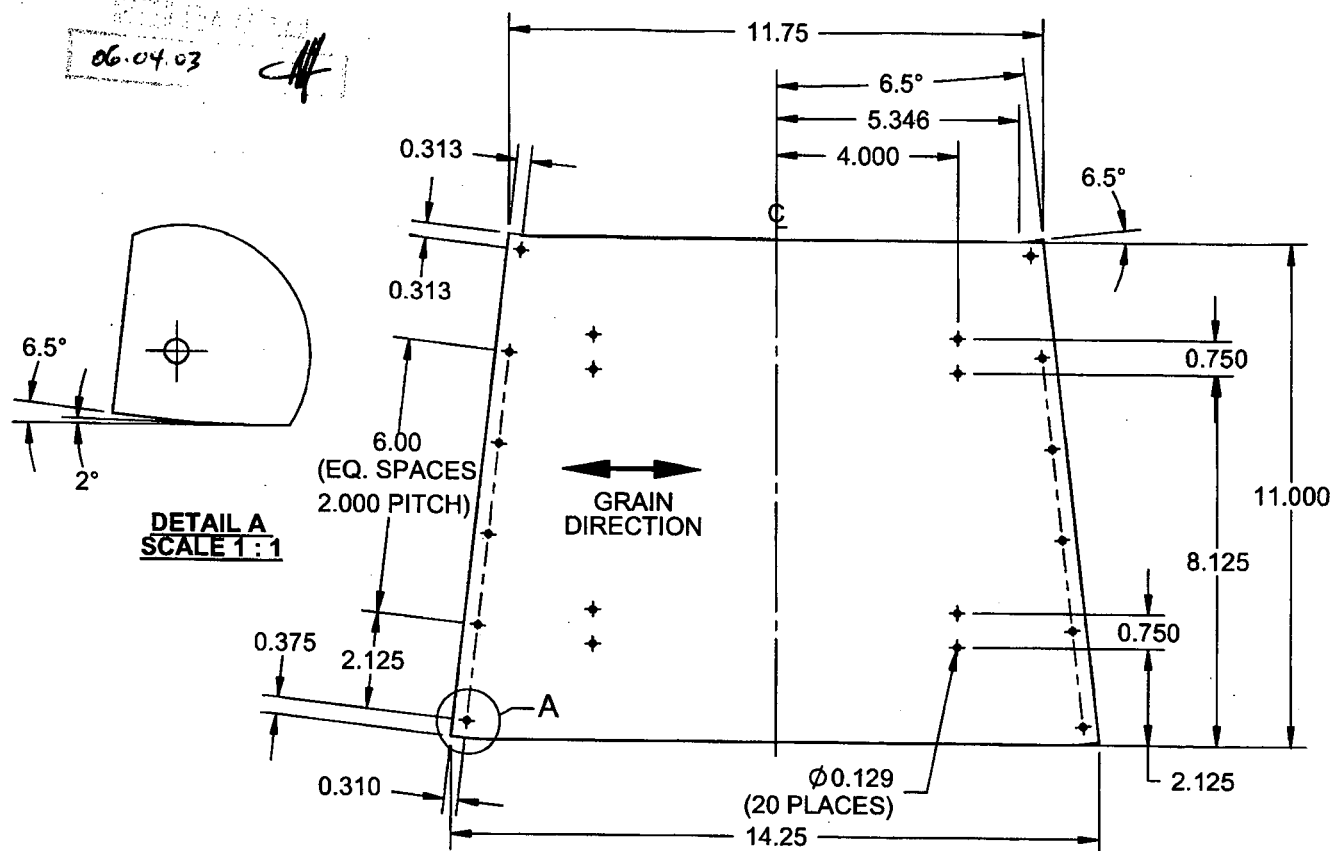
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-3	SUPPORT
3	MS20427M-4	RIVET
1	MS35842-16	CLAMP

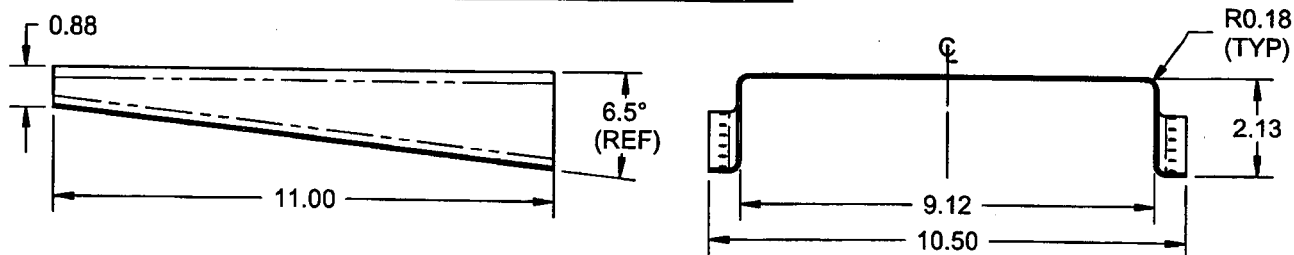
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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:4



D3471-1F BASE FLAT PATTERN



D3471-1 BASE BENDING DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QS
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

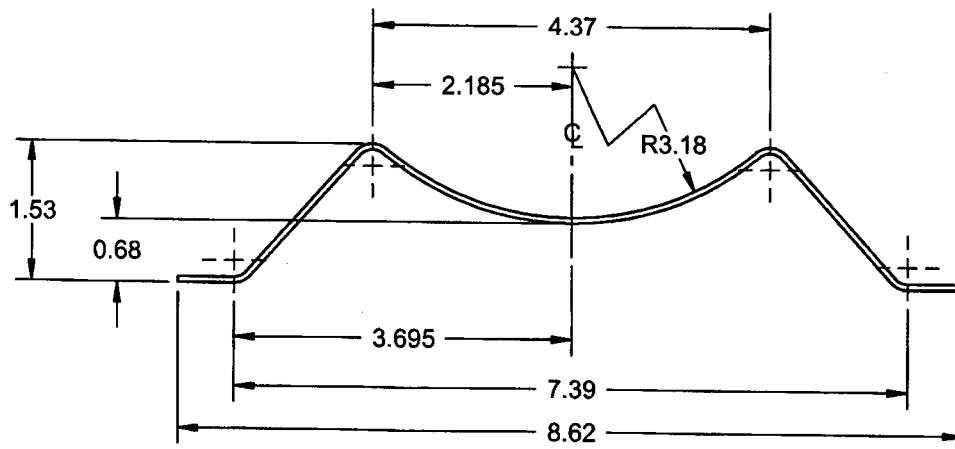
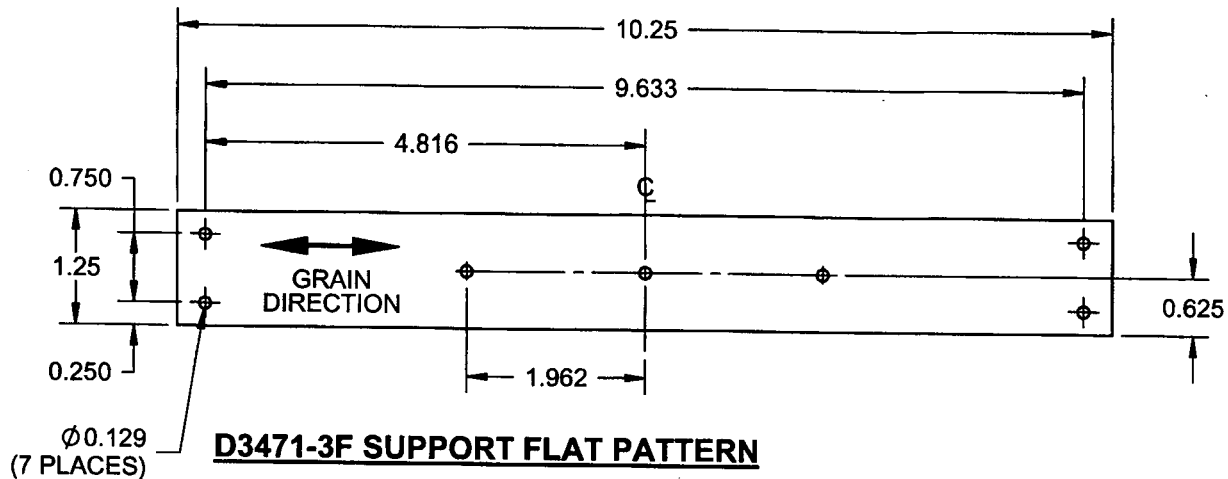
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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT SCALE 1:2	

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

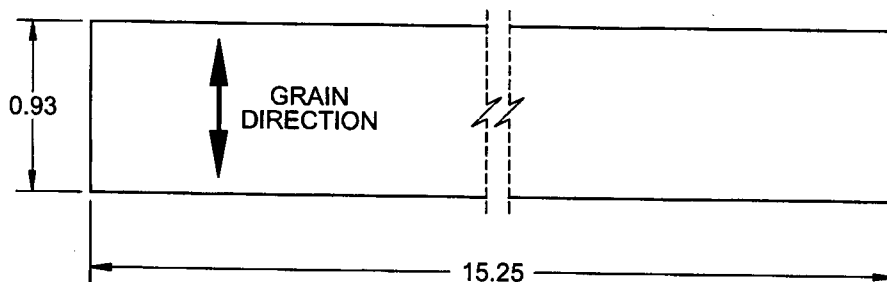
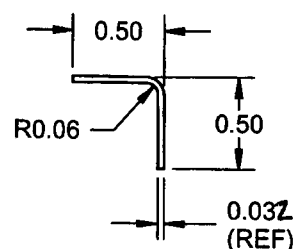
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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT SCALE 1:1	

06.04.03 *A***D3471-5F STIFFENER FLAT PATTERN****D3471-5 STIFFENER BENDING DETAIL****D3471-5 STIFFENER****NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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